

## CLAIMS

1. A spoke for wheels comprising a shaft having opposed longitudinal ends on at least one of which a terminal element carrying a device for the attachment of the spoke to the respective wheel component is fitted by means of fixing means, characterized in that the fixing means comprise a stud-bolt-type threaded connection between the shaft and the terminal element.

2. A spoke according to Claim 1 in which the stud-bolt-type connection comprises an axial hole in the end of the shaft and a thread on the terminal element, the coupling between the hole and the thread being of the threaded or self-tapping type.

3. A spoke according to Claim 1 or Claim 2 in which the shaft is made of a material having a mechanical strength less than that of the material of which the terminal element is made.

4. A spoke according to Claim 3 in which the shaft is made of light alloy.

5. A spoke according to Claim 3 in which the terminal element is made of steel.

6. A spoke according to one or more of the preceding claims in which the self-tapping thread is formed with a conical profile.

7. A spoke according to one or more of the preceding claims in which a driving key is provided in an intermediate portion of the terminal element, for the driving of the terminal element into the shaft.

8. A spoke according to one or more of the preceding claims in which the terminal element is driven into the shaft with interference.

9. A spoke according to one or more of the preceding claims in which the terminal element is provided, at the end remote from the shaft, with means for connection to a nipple.

10. A spoke according to one or more of the preceding claims in which the terminal element is provided, at the end remote from the shaft, with means for connection to a wheel hub.

11. A spoke according to Claim 9 in which the connection means comprise a threaded portion of the terminal element.

12. A spoke according to Claim 10 in which the means for connection to a hub comprise an attachment element.

13. A spoke according to one or more of the preceding claims in which the hole in the shaft is blind and has a greater extent than the threaded portion of the terminal element which is engaged therein, so as to define a chamber in the hole.

5 14. A spoke according to Claim 13 in which the axial extent of the chamber is greater than or equal to one third of the overall axial extent of the blind hole.

10 15. A method for the manufacture of a wheel spoke comprising the steps of preparing a shaft and separately preparing at least one terminal element to be arranged as an extension of the shaft, the shaft being made of a material having a mechanical strength less than that of the material with which the terminal element is made, characterized in that the terminal element is fitted on the shaft by means of a stud-bolt-type connection, firmly fixing the shaft and the terminal together axially.

15 16. A method according to Claim 15 in which the connection is forced with interference.

17. A method according to Claim 15 or Claim 16 in which the stud-bolt-type connection is performed with a self-tapping coupling.

20 18. A wheel spoke produced by press-forging of metal alloy and having a substantially Y-shaped configuration with two shanks at the same end, the shanks having respective threaded portions for the engagement of respective nipples.

19. A spoke according to Claim 18 including a central aperture of a shape corresponding to the external shape of the spoke itself.